

Work Order ID 65944

Thursday, January 27, 2011 1:15:11 PM



Page 1

Item ID: D4018-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Short Basket Lid Assembly (350)					
Start Date: 1/28/2011	Start Qty: 1.00		Cust Item ID:		
Required Date: 2/14/2011	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>mf</u>	Date: <u>11-01-27</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4018	C								

100
 Weld per dwg A/R S.S. rod Batch: 11585 0.00
 Large Fab
 Large Fab
 Memo 0.00
 1- assemble ribs , weld as per dwg D4018 using DT9607B
 2- weld hinge (3) and Mounting brackets as per dwg D4018
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D4018
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

QC 11.02.03

110
 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 QC
 Quality Control Memo 0.00

11/02/04 (X)
AA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
				Sulozlog		(X)			
160 Packaging Packaging	Identify as per dwg & Stock Location: Memo used on w/o 65607 D4032-041	0.00 0.00							
						14	20	11/02/08	
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
									11/02/08 mf 11-02-08

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Picklist Print

Thursday, January 27, 2011 1:15:08 PM

Page 1

Work Order ID: 65944

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)









Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D4018-1  Rib		Manufactured	No			100	Each	2.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					59252			2					
 D4018-3  Rib		Manufactured	No			100	Each	2.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					59253			2					
 D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	14.0000	3	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14					
					64845			8					
					65425			6					
 D4018-5  Rib		Manufactured	No			100	Each	16.0000	6	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				16					
					64067			16					

Cpl 11.02.02
65915
365623 → (2)

Cpl 11.02.02

(2)
Cpl 11.02.02

(3)
Cpl 11.02.02

(6)

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Work Order ID: 65944

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

* D4035-041



Lid Rib Assembly, Fwd (350 Basket)

Manufactured No

100 Each

1.0000



1

1

Pl 11.02.02

Location

Loc Qty

Loc Code

WA

1

64849

1

365426 → ①

✓ D4035-043



Lid Rib Assembly, Aft (350 Basket)

Manufactured No

100 Each

1.0000



1

1

Pl 11.02.02

Location

Loc Qty

Loc Code

WA

1

64850

1

365427 → ①

✓ D2581



Mounting Bracket

Manufactured No

100 Each

29.0000



2

2

Pl 11.02.02

Location

Loc Qty

Loc Code

WA

29

64112

20

64425

9

②

* D4020-7



Mesh (350 Basket Short, Lid)

Manufactured No

100 Each

0.0000



1

1

365717 → ① Pl 11.02.02

✓ D4021-3



Data Plate

Manufactured No

100 Each

3.0000



1

1

Pl 11.02.02

Location

Loc Qty

Loc Code

WA

3

56050

1

64924

2

①

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, January 27, 2011 1:15:09 PM

Page 3

Work Order ID: 65944



Parent Item: D4018-041



Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label

M115050 (x1)



jd

11/02/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

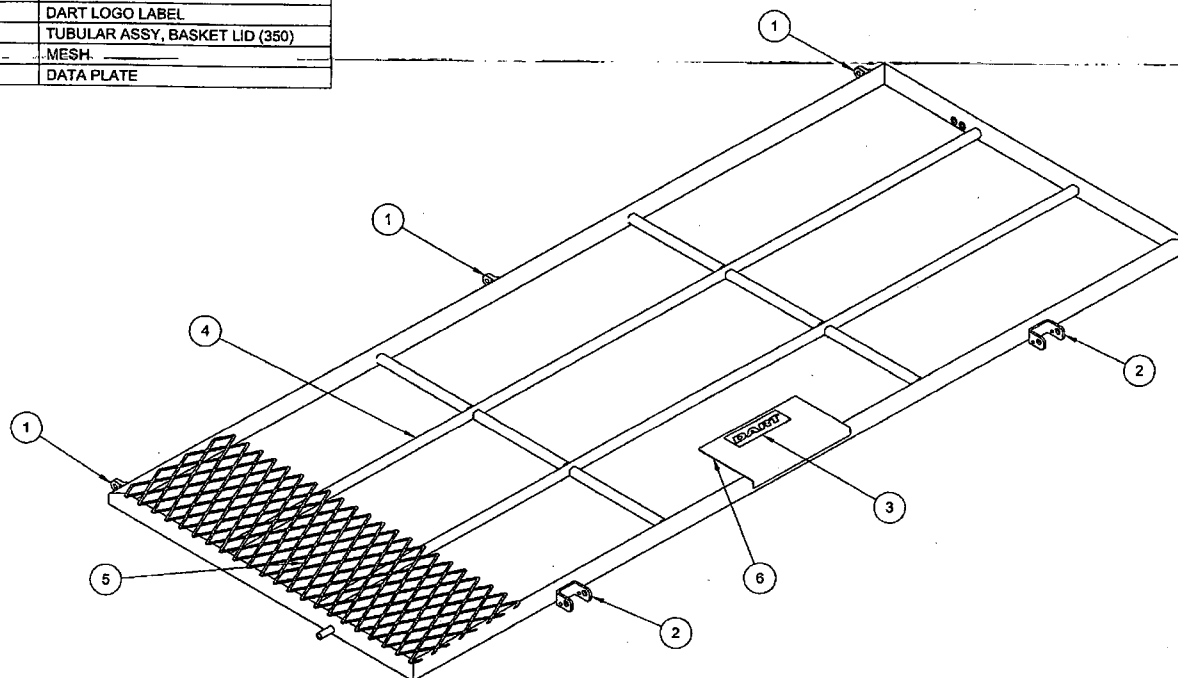
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12
ECN 10-916

C	REMOVED D4088-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.08.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4018
REV. C
SHEET 1 OF 4
TITLE
SHORT BASKET LID ASSY (350)
SCALE
NTS

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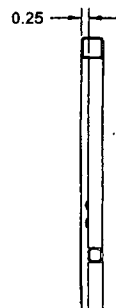
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NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

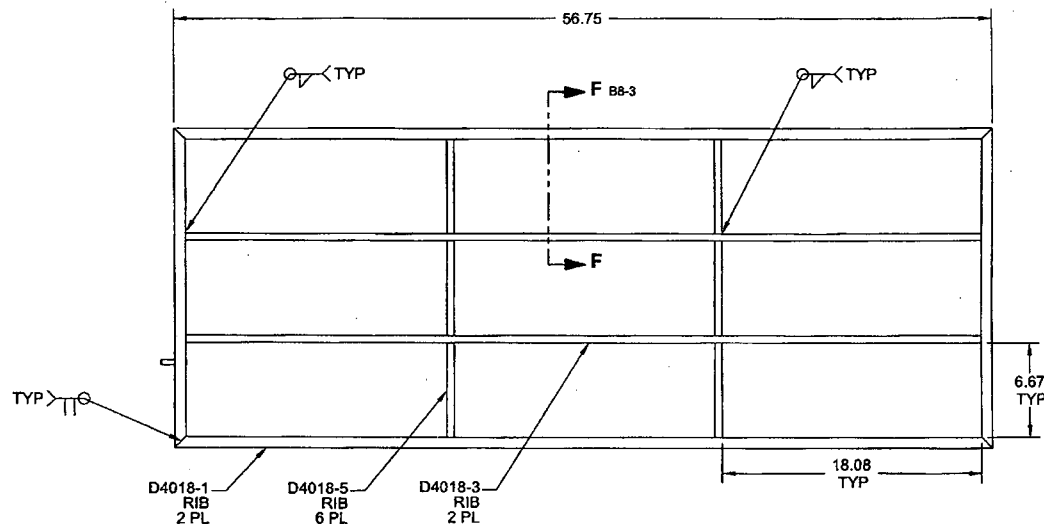


D4035-041
RIB ASSY, FWD

SECTION F-F C3-3



D4035-043
RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

#65944

RELEASED
10.08.12 UP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ASS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

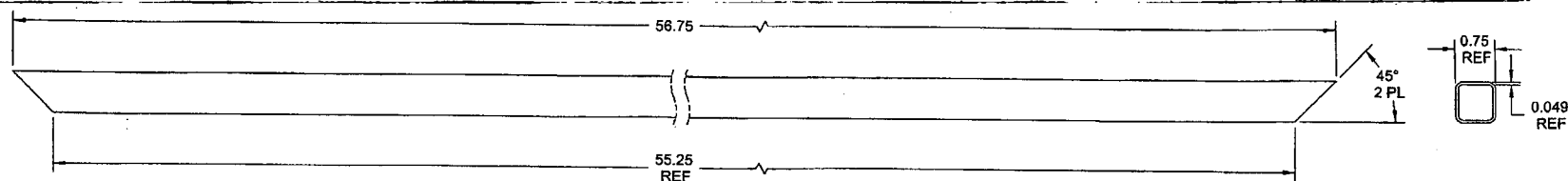
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8 7 6 5 4 3 2 1

D

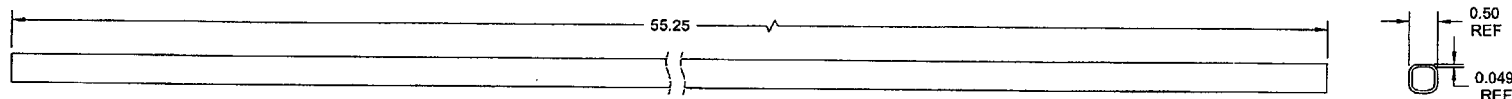
D



D4018-1 RIB

C

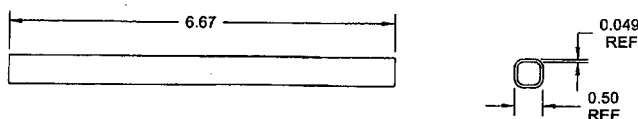
C



D4018-3 RIB

B

B



D4018-5 RIB

RELEASED
10-08-05

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO.	REV. C
MFG. APPR.	h	D4018	SHEET 4 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	SHORT BASKET LID ASSY (350) NTS	
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8 7 6 5 4 3 2 1

A

A

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